












Date: Monday, 23/07/2007 2:24:39 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM
Job Number : 33282	
Estimate Number : 10772	
P.O. Number : N/A	Part Number : D34425
This Issue : 23/07/2007 S.O. No. : N/A	Drawing Number : D3442 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 33282	Material : N/A
Written By : _____	Due Date : 30/07/2007
Checked & Approved By : _____	Qty: 25 Um: Each
Comment : Est. A 05.09.02 New issue KJ/JLM est B 07.07.23 waterjet EC verified by: JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S16GA 304/316 .063 Sheet
  <p>Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.5250 sf(s)          304/316 SS 0.063" Sheet          batch: <del>M101823(11) M105061(11) B 07 07 07</del> M103961 SAD 07/08/02 (25)</p>	
2.0	WATER JET FLOW WATER JET
  <p>Comment: FLOW WATER JET          1-Cut as per Dwg D3442          Dwg Rev: A          Prog Rev: A          2-Deburr if necessary SAD 07/08/08 (25) SAD 07/08/02 (25)</p>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/08/02 (25)</p>	
4.0	QC8 SECOND CHECK
  <p>Comment: SECOND CHECK E 07/08/09 (25)</p>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
  <p>Comment: PACKAGING RESOURCE #1          Identify and Stock          Location: _____ E 07/08/09 (25)</p>	

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 33282

Part Number: D34425

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(25)

5/8/08

Job Completion



CL67/08/10

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	:	SHIM
Job Number	: 33282			
Estimate Number	: 10772			
P.O. Number	:	Part Number	:	D34425
This Issue	: 7/4/2007 S.O. No.	Drawing Number	:	D3442 REV A
Prsht Rev.	: NC	Project Number	:	N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	:	A
Previous Run	: 24246	Material	:	
Written By	:	Due Date	:	7/20/2007 Qty:
Checked & Approved By	:			20 Um:
Comment	:			Each

Job Number:



1.0	PG	PURCHASING
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Issue P/O: \_\_\_\_\_  
Email or Ship DXF file to vendor  
Laser Cut flat pattern per Dwg D3442  
Possible Supplier: Industrial Laser  
Material release note is required

2.0 D34425F Shim



Comment: Qty.: 1.0000 U(s)/Unit Total : 20.0000 U(s)  
Shim

3.0 PACKAGING 1 PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1  
Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

40 QC6 DIMENSIONAL CHECK



**Comment:** DIMENSIONAL CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1  
Identify and Stock  
Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 7/4/2007 10:17:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 33282

Part Number: D34425

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

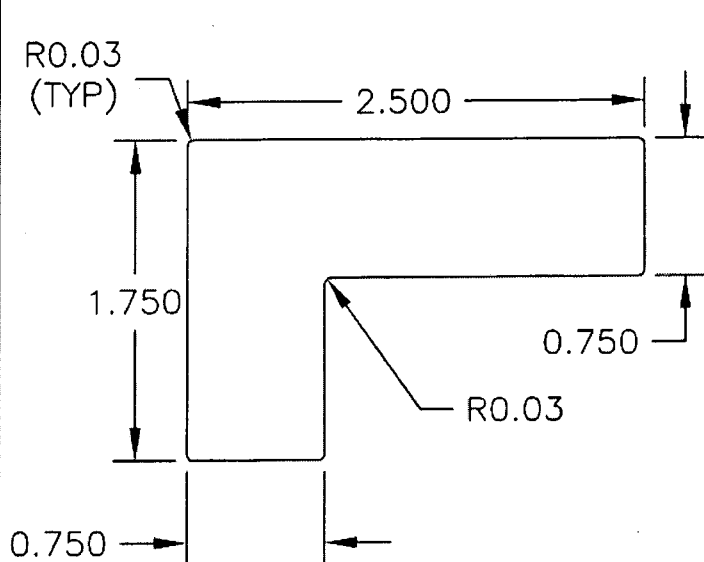
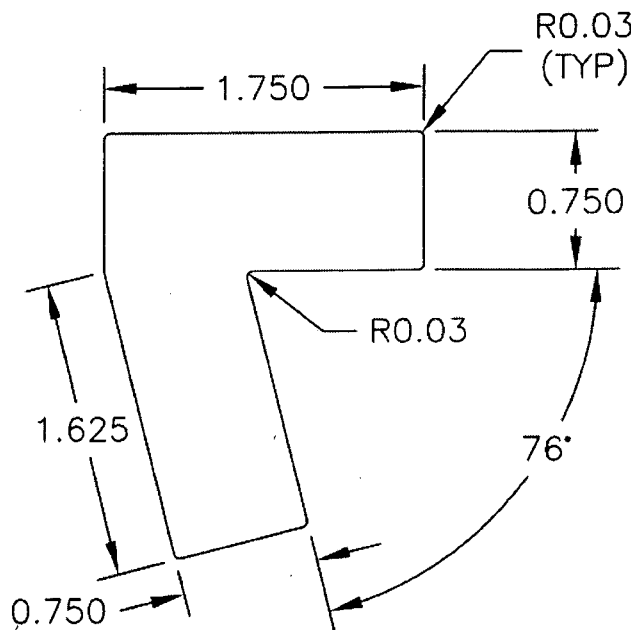
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

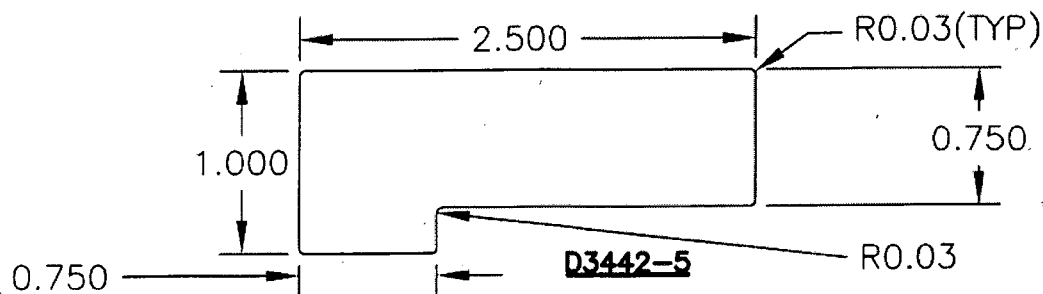
**NOTE:** Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03	TITLE SHIM		SCALE 1:1
A	05.06.03	NEW ISSUE	

**D3442-1****D3442-3****D3442-1/-3 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)  
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3442-5****D3442-5 SHIM**

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **33282**

**RELEASED**05.08.19 *[Signature]***Copyright © 2005 by DART AEROSPACE LTD**

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DART AEROSPACE LTD		Work Order:	33282
Description: Shim		Part Number:	034425
Inspection Dwg: 33281	Rev: A	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X

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[illegible]

Measured by: <b>SAD</b>	Audited by: <b>En</b>	Prototype Approval: <b>N/A</b>
Date: <b>07/08/02</b>	Date: <b>07/08/02</b>	Date: <b></b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	